VAUTID 100Mo

Tubular wire
Hardfacing material for high abrasion and moderate temperatures

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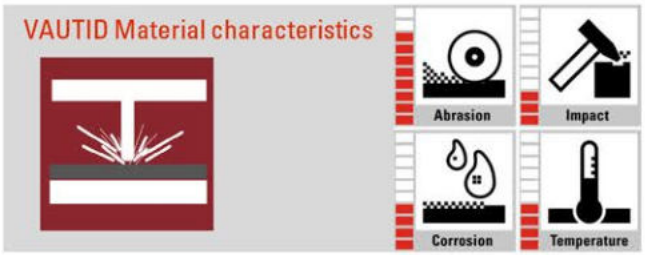
VAUTID Material characteristics



Specification	Tubular wire electrode DIN EN 14700 T ZFe15 g
Material type Alloy components	High-chrome-high-carbon hard alloy on iron base with molybdenum additions C – Cr – Mo – Fe
Weld deposit characteristics	VAUTID 100Mo produces a war-resistant, austenitic, primary carbide-containing weld deposit. It is very resistant to abrasion. The material cannot be flame cut, offers good resistance to scaling and cannot be machined. The weld deposit exhibits cracks
Weld deposit properties	Hardness (acc. DIN 32525-4): 60-65 HRC*
Recommended applications	Recommended particularly for the hardfacing of parts subjected to strong abrasion and average shock stress, e.g. screws, sieves, stirrer blades, sand slingers, top coat on dredger teeth and crushing rolls. The application temperatures should not exceed 350° C
Standard sizes	Tubular wires: Diameter 1,2 / 1,6 / 2,0 / 2,4 / 2,8 / 3,2 mm Packing: Mandrels 15 kg, Reels 25 kg, Drums 250 kg

* subject to common industrial fluctuations

Welding instructions for tubular wires:

VAUTID 100Mo is welded without inert gas on the +pole (a.c. possible). Weave technique is usual. The arc should be held as short as possible. Preheating decreases the generation of stress cracking on the hardfacing.

Diameter (mm)	Current (A)	Voltage (V)	Stick out (mm)
1,2	100 – 220	18 – 22	20 – 30
1,6	150 – 270	24 – 27	20 – 40
2,0	180 – 300	25 – 28	25 – 40
2,4	230 – 350	26 – 29	25 – 50
2,8	260 – 420	27 – 29	30 – 55
3,2	290 – 470	28 – 30	30 – 55

Welding positions (EN ISO 6947): PA, PB

This data sheet corresponds to the present state of production (October 2016) and can be changed anytime.

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